

We Claim:

1. A process for preparing monoesters comprising the
5 step of reacting at least one diol with at least one
carboxylic acid in a biphasic solvent system, said
carboxylic acid being sufficiently water soluble to allow
esterification to occur, and said biphasic solvent system
comprising water and at least one aprotic solvent in which
10 the resulting monoester has greater solubility than in
water.

2. The process of claim 1 wherein said diol is a
diprimary or disecundary diol.
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3. The process of claim 2 wherein said diol is a
diprimary diol.

4. The process of claim 1 wherein said diol is
20 selected from the group consisting of 1,8-octanediol, 1,9-
nonanediol, 1,10-decanediol, 1,11-undecanediol, 1,4-
cyclohexanediol, and mixtures thereof.

5. The process of claim 4 wherein said diol is
25 selected from the group consisting of 1,8-octanediol, 1,9-
nonanediol, 1,11-undecanediol, and mixtures thereof.

6. The process of claim 1 wherein said diol comprises
two hydroxyl groups having substantially equal reactivity.
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7. The process of claim 1 wherein said diol is
symmetric.

8. The process of claim 1 wherein said diol has less than about 14 carbon atoms.

5 9. The process of claim 1 wherein said carboxylic acid has a solubility in water of at least about 20% by weight at 20°C.

10 10. The process of claim 9 wherein said carboxylic acid has a solubility in water of at least about 50% by weight at 20°C.

15 11. The process of claim 10 wherein said carboxylic acid has a solubility in water of about 100% by weight at 20°C.

12. The process of claim 1 wherein said carboxylic acid has a solubility in water greater than or equal to that of isobutyric acid.

20 13. The process of claim 12 wherein said carboxylic acid is selected from the group consisting of formic acid, acetic acid, trifluoroacetic acid, n-butyric acid, pyruvic acid, propionic acid, and mixtures thereof.

25 14. The process of claim 13 wherein said carboxylic acid is selected from the group consisting of formic acid, acetic acid, and mixtures thereof.

30 15. The process of claim 14 wherein said carboxylic acid is acetic acid and the resulting monoester is a monoacetate.

16. The process of claim 15 further comprising the steps of:

(a) oxidizing the remaining hydroxyl group of said monoacetate to form an aldehyde, and

5 (b) reacting said aldehyde with an alkylidene phosphorane to form the corresponding olefinic monoacetate.

17. The process of claim 1 wherein said aprotic solvent has a polarity index between about 1.5 and about
10 3.5.

18. The process of claim 17 wherein said aprotic solvent has a polarity index between about 2.0 and about
15 3.0.

19. The process of claim 1 wherein said aprotic solvent is an aromatic or ether solvent.

20. The process of claim 19 wherein said solvent is selected from the group consisting of toluene, benzene, chlorobenzene, ethylbenzene, xylenes, trifluorotoluene, dichlorobenzene, methyl tert-butyl ether (MTBE), diethyl ether, diisopropyl ether, dibutyl ether, and mixtures thereof.
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21. The process of claim 19 wherein said solvent is an aromatic solvent.

22. The process of claim 21 wherein said solvent is
30 toluene.

23. The process of claim 1 wherein said diol and said carboxylic acid are reacted in the presence of an acid

catalyst.

24. The process of claim 23 wherein said catalyst is
selected from the group consisting of sulfuric acid, nitric
5 acid, hydrochloric acid, and mixtures thereof.